

Work Order ID 121665

Thursday, June 26, 2014 3:06:17 PM

121665

Page 1

Item ID: DSI 9464-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube Tuning

Start Date: 6/20/14 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/26/14 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-06-30 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3955	A
DSI 9464	B

100	Document Control	0.00
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100

DC

Doc.Control -USB or Paperwork

Memo

0.00

Photocopy bluefile & type labels per PPP DSI 9464-011
CHG001

110

Pick Kit

0.00

110

Packaging

Packaging

Memo

0.00

DAS
27
9-89

MLJ 15-03-30
2

2x

DAS
46
9-89

MAR 31 2015

2x

DAS
27
9-89

MAR 30 2015



DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 121665

Thursday, June 26, 2014 3:06:17 PM

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Page 2

Item ID: DSI 9464-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube Tuning

Start Date: 6/20/14 Start Qty: 2.00

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Cust Item ID:

Required Date: 6/26/14 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00				(2x)	DAS 46 9-89		MAR 31 2015
120 QC Quality Control	Memo	0.00							
130		0.00				(2x)	DAS 46 9-89		MAR 31 2015
130 Packaging Packaging	Memo Identify and pack for shipping as per PPP DSI 9464-011 Location: <u>6622</u> * 1 sold PPP rev: _____	0.00							
140	QC21- Final Inspection - Work Order Release	0.00							
140 QC Quality Control	Memo	0.00							

MS-31

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Material									
Operator									
Offset/Setup									
Process									
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Training									
Transport									
Unapproved									

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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Thursday, June 26, 2014 3:06:15 PM

Page 1

Work Order ID: 121665

121665

Parent Item: DSI 9464-011

DSI 9464-011

Parent Item Name: Skidtube Tuning

Start Date: 6/20/14

Required Date: 6/26/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC
per ECN10-553 DD 10.04.19 verified byEC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3955-041 *D3955-041* Doubler Assembly	DAS 46 9-89	Manufactured	No			110	Each	4.0000	2	4		DAS 27 9-89 MAR 30 2015	DAS 27 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST072		4		B12163		4			
				101919		4							
D3955-3 *D3955-3* Cover Plate	DAS 46 9-89	Manufactured	No			110	Each	10.0000	2	4		DAS 27 9-89 MAR 30 2015	DAS 27 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST077		6							
				101922		6		B127510		4			
				ST079		4							
				101922		4							
D3955-5 *D3955-5* Plate	DAS 46 9-89	Manufactured	No			110	Each	2.0000	2	4		DAS 27 9-89 MAR 30 2015	DAS 27 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST077		2		B113651		2			
				101923		2							
D3955-7 *D3955-7* Plate	DAS 46 9-89	Manufactured	No			110	Each	4.0000	6	12		DAS 27 9-89 MAR 30 2015	DAS 27 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST071		4		B121561		4			
				102121		4		B101924		2			
								B127552					

DQA: _____ Date: _____



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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Page 2

Thursday, June 26, 2014 3:06:15 PM

Work Order ID: 121665

121665

Parent Item: DSI 9464-011

DSI 9464-011

Parent Item Name: Skidtube Tuning

Start Date: 6/20/14

Required Date: 6/26/14

Start Qty: 2.00

Required Qty: 2.00

D3955-21 Manufactured No

110 Each 8.0000 2 4

D3955-21
Gasket

DAS
46
9-29

**

DAS
27
MAR 30 2015

Location

Loc Qty

Loc Code

ST071

8

113843

8

110 Each 10.0000 2 4

D3955-23 Manufactured No

D3955-23
Template

DAS
46
9-29

**

DAS
27
MAR 30 2015

Location

Loc Qty

Loc Code

ST078

10

101921

8

95911

2

110 Each 598.0000 38 76

CR3212-4-04 Purchased No

CR3212-4-04
Cherry Rivet

DAS
46
9-29

**

DAS
27
MAR 30 2015

Location

Loc Qty

Loc Code

ST321

598

123265

28

m126534

10

m128228

560

110 Each 414.0000 4 8

AN3-5A Purchased No

AN3-5A
Bolt

DAS
46
9-29

**

DAS
27
MAR 30 2015

Location

Loc Qty

Loc Code

ST350

414

117423

45

124561

50

m126559

92

m129246

77

m129507

150

MB1420

8

Thursday, June 26, 2014 3:06:16 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Material									
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Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Thursday, June 26, 2014 3:06:16 PM

Work Order ID: 121665

121665

Parent Item: DSI 9464-011

DSI 9464-011

Parent Item Name: Skidtube Tuning

Start Date: 6/20/14

Required Date: 6/26/14

Start Qty: 2.00

Required Qty: 2.00

AN3-6A

DAS
46
9-89

Purchased

No

110

Each

315.0000

4

8

DAS

27
MAR 30 2015

AN3-6A

Bolt

Location

Loc Qty

Loc Code

ST351

311

116390

9

M128403

2

M128739

150

M128978

150

ST511

4

M127044

4

m130466

8

AN3-7A

DAS
46
9-89

Purchased

No

110

Each

176.0000

4

8

DAS

27
9-89

MAR 30 2015

AN3-7A

Bolt

Location

Loc Qty

Loc Code

ST349

176

M126175

76

M128634

50

M129507

50

m129706

8

AN3-10A

DAS
46
9-89

Purchased

No

110

Each

416.0000

4

8

DAS

27
MAR 30 2015

AN3-10A

Bolt

Location

Loc Qty

Loc Code

ST351

116

m127817

35

m128403

81

ST511

300

m128813

150

m128936

150

m131220

8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Thursday, June 26, 2014 3:06:16 PM

Work Order ID: 121665

121665

Parent Item: DSI 9464-011

DSI 9464-011

Parent Item Name: Skidtube Tuning

Start Date: 6/20/14

Required Date: 6/26/14

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0332J

Purchased

No

110

Each

3,205.000

6

12

DAS

27

9-89

NAS1149D0332.J DAS

Washer

46

9-89

MAR 30 2015

Location

Loc Qty

Loc Code

ST276

3205

m128606

238

m128612

2767

m129624

200

m131624

12

MS21042L3

Purchased

No

110

Each

5,550.000

2

4

DAS

27

9-89

MS21042L3 DAS

Nut

46

9-89

MAR 30 2015

Location

Loc Qty

Loc Code

ST307

5550

123900

955

M126333

54

M127410

13

M127831

41

M128401

48

M128754

4439

m131624

4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

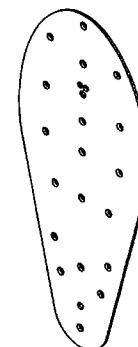
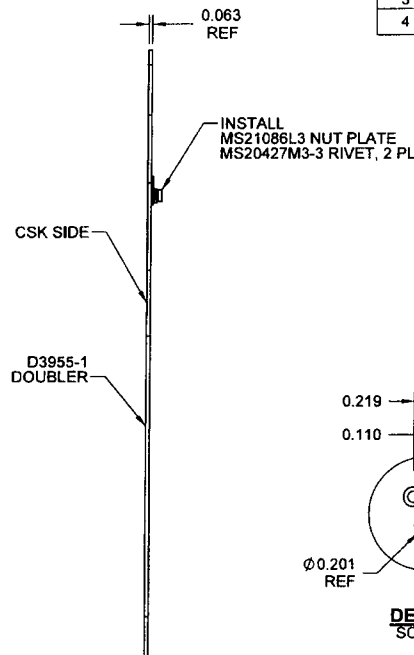
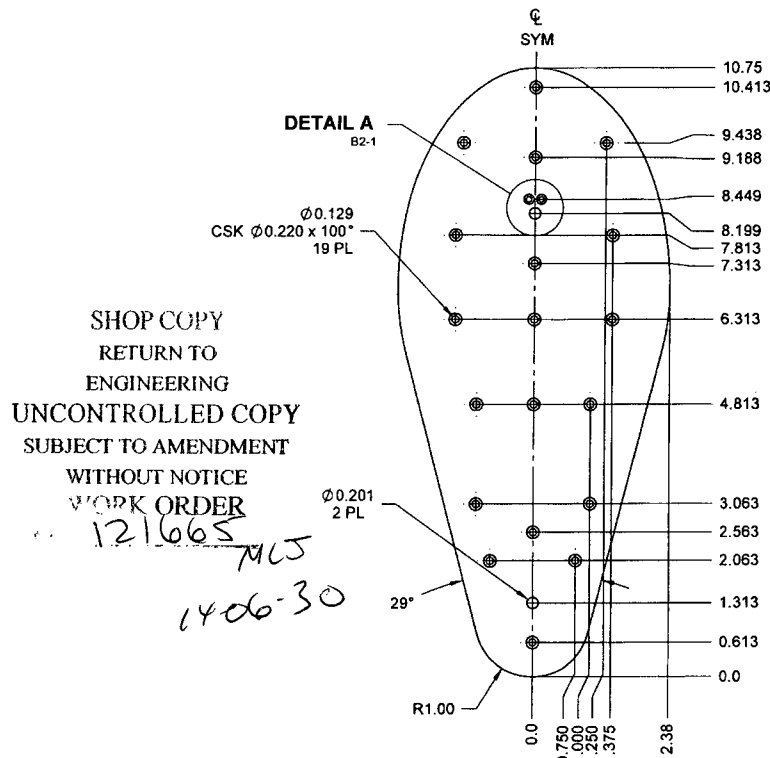
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3955-041	DOUBLER ASSY
2	1	D3955-1	DOUBLER
3	1	MS21086L3	NUT PLATE
4	2	MS20427M3-3	RIVET



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
121665
MLJ
1406-30

D3955-1 DOUBLER

D3955-041 DOUBLER ASSEMBLY

RELEASED
09/07/21

- D3955-1 NOTES:**
- 1) MATERIAL: 6061-T6 ALUMINUM, 0.063 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.063)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N "D3955-041" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.25 lbs

REV.	DESCRIPTION	RF	DATE
A	NEW ISSUE		09.07.21
DESIGN	DS		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.07.21		

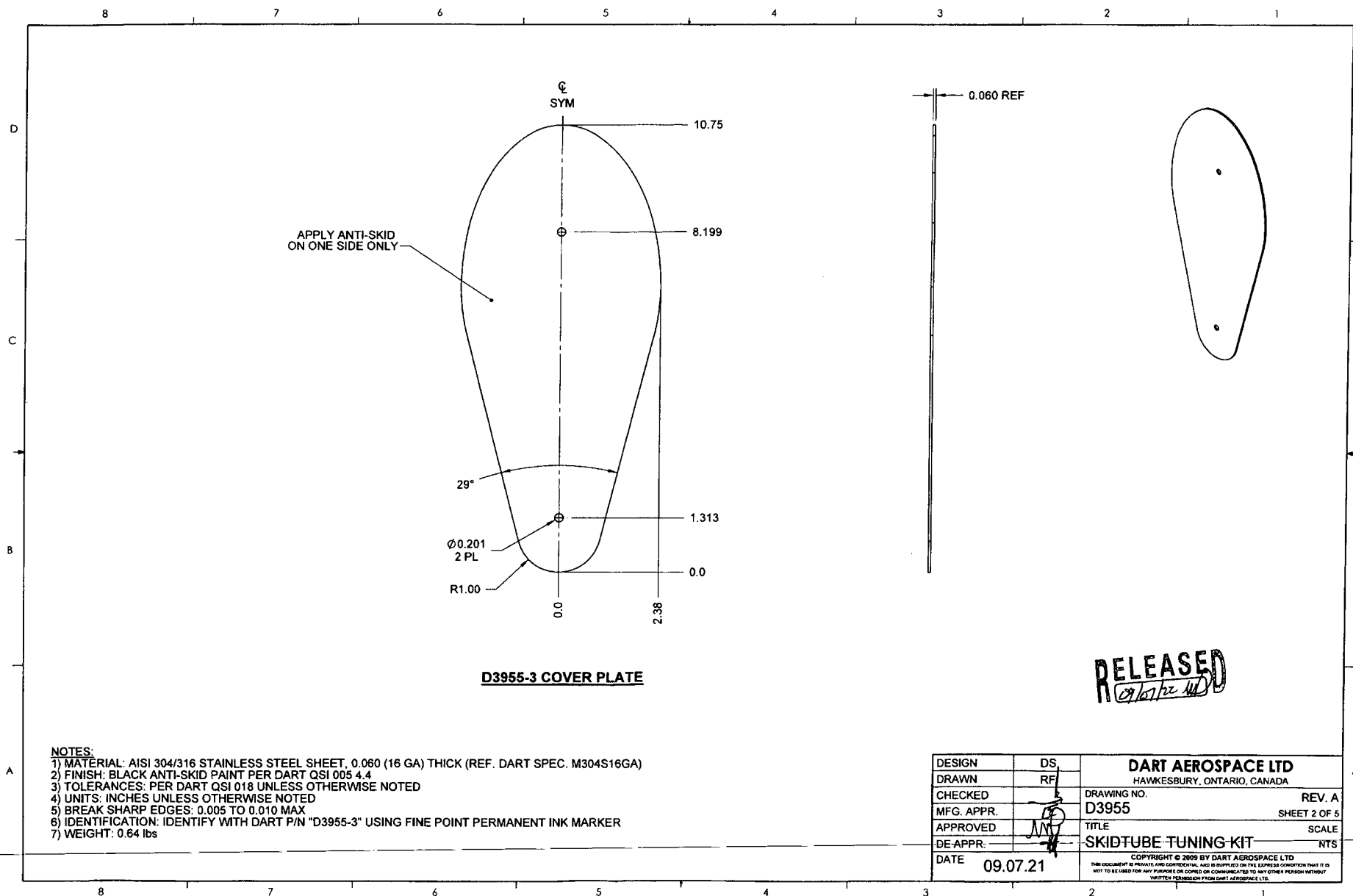
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

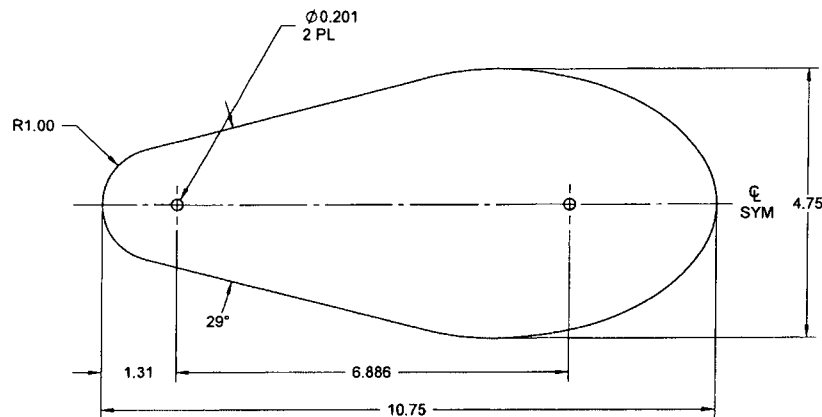
DRAWING NO.
D3955

TITLE
SKIDTUBE TUNING-KIT

REV. A
SHEET 1 OF 5
SCALE
NTS

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D3955-X PLATE

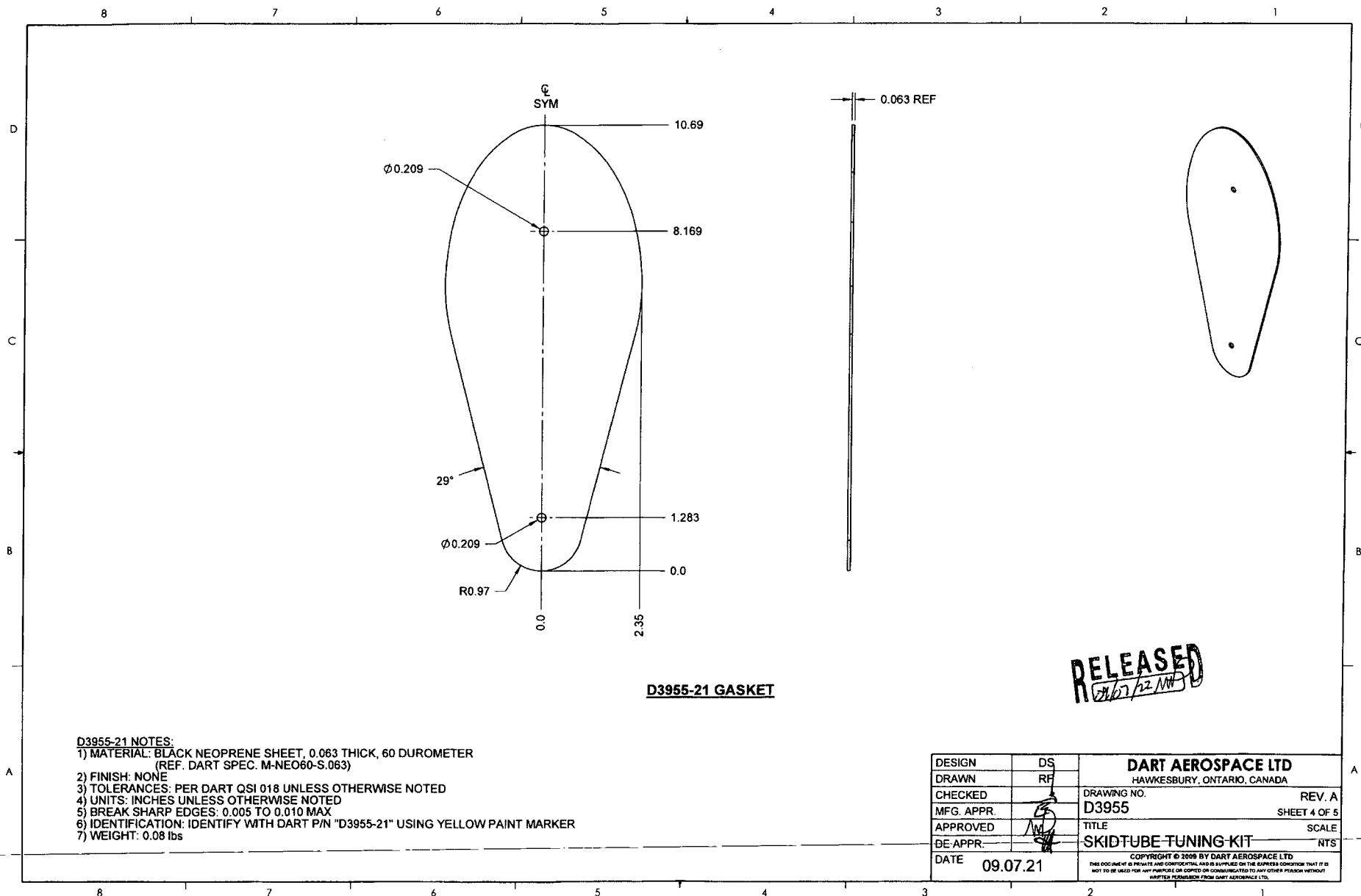
General Table			
P/N	T (in)	T (GA)	WEIGHT (lbs)
D3955-5	0.060	16	0.64
D3955-7	0.120	11	1.28

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, T (GA) THICK (REF. DART SPEC. M304STGA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: SEE TABLE

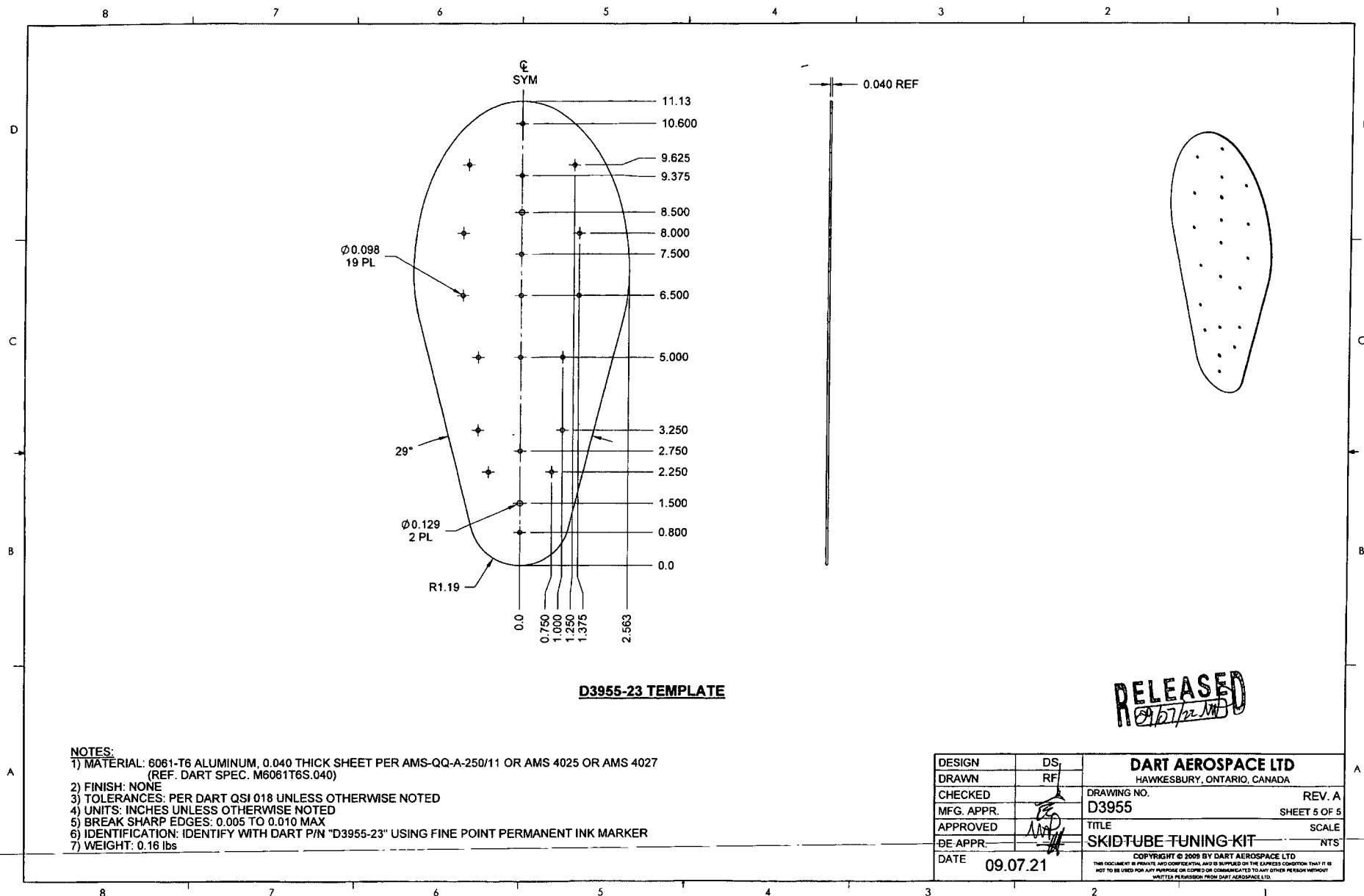
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09/07/21 NAD

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D3955-21 GASKET

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NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.040 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.040)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-23" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.16 lbs

RELEASED
2/17/2010

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MFG. APPR.		D3955	SHEET 5 OF 5
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DART SERVICE INSTRUCTION

TO AMEND:

INSTALLATION INSTRUCTIONS D205-634 REV. F OR EARLIER,
INSTALLATION INSTRUCTIONS D204-635 REV. F OR EARLIER,
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-634 REV. 3 OR EARLIER,
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D204-635 REV. 3 OR EARLIER

REF CANADIAN STC: SH96-88
REF FAA STC: SR00563NY
REF EASA STC: EASA.IM.R.S.01303

Purpose:

The Purpose of the DSI 9464-011 Kit is to allow operators to tune landing gear utilizing D205-634-041 / D204-635-041 skidtubes in order to eliminate vibration. This kit consists of various weights that can be attached to the fwd cap of the Dart skidtube.

Procedure:

Note: Installer must be careful not to damage underlying skidtube during drilling operations.

- 1) Locate D3955-23 template on the fwd cap of the skidtube. Transfer drill 19 x Ø0.098" holes from the D3955-23 template to the skidtube cap using a #30 drill.
- 2) Transfer drill 1 x Ø0.625" (15.8 mm) from the D3955-23 template to the skidtube as shown in Figure 1.
- 3) Transfer drill 1 x Ø0.201" (#7 drill) from the D3955-23 template to the skidtube as shown in Figure 1.
- 4) Deburr the drilled holes in fwd cap. Ensure the top surface of the cap is clear of debris.
- 5) Apply a layer of Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 Class B2 sealant between the D3955-041 Doubler and the existing skidtube cap. Install D3955-041 Doubler Assy. using 19 x CR3212-4-04 rivets as shown in Figure 1. The nutplate in the D3955-041 Doubler Assy should pass thru the Ø0.625 hole in the cap.
- 6) Install tuning plates as shown in Figure 2. Torque AN3 bolts 15-25 in-lb (1.7-2.8 N-m). Test the landing gear for vibration.
- 7) If vibration persists, repeat step 6 until vibration is eliminated.
- 8) Update Weight & Balance as outlined below.

Weight And Balance:

The weight and balance increase associated with the installation of the DSI 9464-011 kit will depend on the number of plates that are installed to tune the gear. The weight of individual plates are given in the Parts List Table. The longitudinal arm for the installation of the DSI 9464-011 kit is 40.0 in (1.02 m) on 205/210/212/214/412 models and 42.0 in (1.07 m) on 204 models.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 10.04.14
CERT. NO.: SH96-88
ISSUE NO.: 3

B	ADD REF TO D204-635	CP	10.04.14
A	NEW ISSUE	RF	09.07.21
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		DSI 9464	SHEET 1 OF 3
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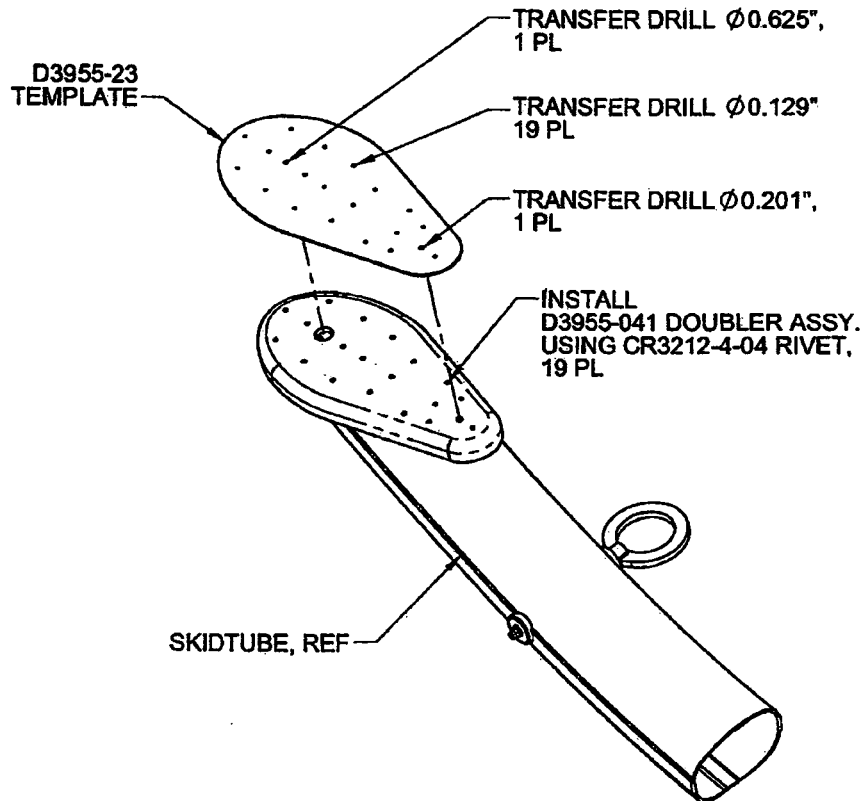


Figure 1

CANADA
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BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.04.14
CERT. NO.: SH96-88
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MFG. APPR.	N/A	DSI 9464	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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Part List

Qty -011	Part Number	Description	Weight
X	DSI 9464-011	SKIDTUBE TUNING KIT	N/A
2	D3955-041	DOUBLER ASSEMBLY	0.25 lb/ 0.11 kg
2	D3955-3	COVER PLATE	0.64 lb/ 0.29 kg
2	D3955-5	0.063" THICK PLATE	0.64 lb/ 0.29 kg
6	D3955-7	0.125" THICK PLATE	1.28 lb/ 0.58 kg
2	D3955-21	GASKET	0.08 lb/ 0.04 kg
2	D3955-23	TEMPLATE	N/A
38	CR3212-4-04	RIVET	N/A
4	AN3-5A	BOLT	N/A
4	AN3-6A	BOLT	N/A
4	AN3-7A	BOLT	N/A
4	AN3-10A	BOLT	N/A
6	NAS1149D0332J	WASHER	N/A
2	MS21042L3	NUT (OR MS21042-3)	N/A

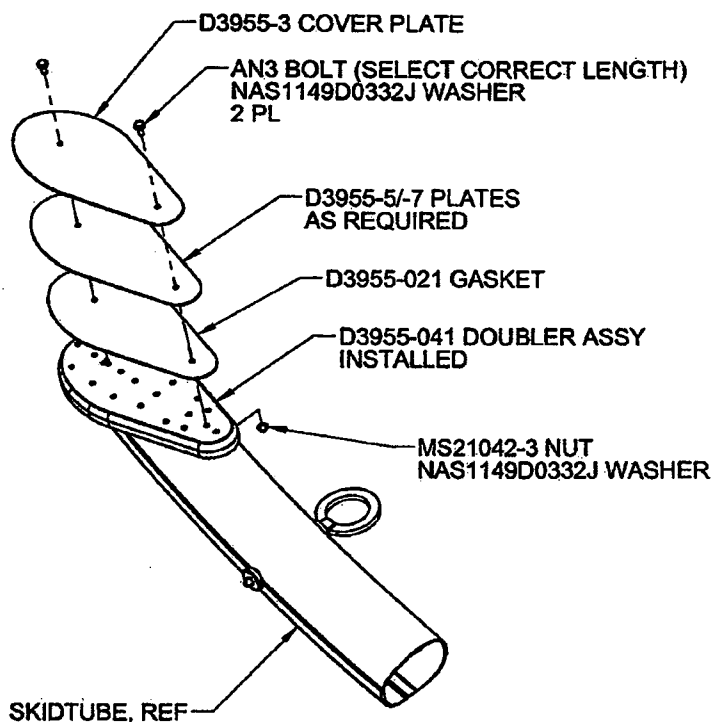


Figure 2

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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BY: *[Signature]*
D. SHEPHERD (DE # 02)

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REFERENCE ONLY

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Part List

Qty -011	Part Number	Description	Weight
X	DSI 9464-011	SKIDTUBE TUNING KIT	N/A
2	D3955-041	DOUBLER ASSEMBLY	0.25 lb/ 0.11 kg
2	D3955-3	COVER PLATE	0.64 lb/ 0.29 kg
2	D3955-5	0.063" THICK PLATE	0.64 lb/ 0.29 kg
6	D3955-7	0.125" THICK PLATE	1.28 lb/ 0.58 kg
2	D3955-21	GASKET	0.08 lb/ 0.04 kg
2	D3955-23	TEMPLATE	N/A
38	CR3212-4-04	RIVET	N/A
4	AN3-5A	BOLT	N/A
4	AN3-6A	BOLT	N/A
4	AN3-7A	BOLT	N/A
4	AN3-10A	BOLT	N/A
6	NAS1149D0332J	WASHER	N/A
2	MS21042L3	NUT (OR MS21042-3)	N/A

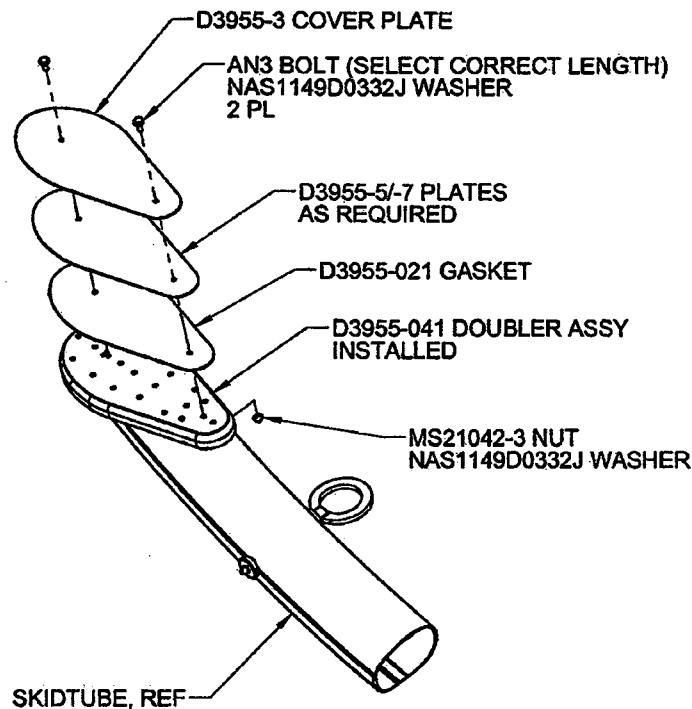


Figure 2

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.04.14
CERT. NO.: SH96-88
ISSUE NO.: 3

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